

Date: Tuesday, 12/12/2006 10:31:54 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIGHT ARM WELDMENT
Job Number : 29904	
Estimate Number : 11876	
P.O. Number : N/A	Part Number : D33547
This Issue : 12/12/2006 S.O. No. : N/A	Drawing Number : D3354 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 26768	Material : N/A
Written By : <u>JA</u>	Due Date : 1/10/2007
Checked & Approved By : <u>JA 061212</u>	Qty: 16 Um: Each
Comment : est rev. A 06.01.14 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B1000X02000	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.5597 f(s)/Unit Total: 8.9544 f(s)

1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 1.00"

Batch: M19296 J.F. 06/12/18

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 6.100" long

J.F. 06/12/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA611 and Dwg D3353

2- Deburr

JL/J.F. 06/12/18

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/J.F. 06/12/18

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JA 06/12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Handwritten Date: 07/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/12/2006 10:31:55 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 29904

Part Number: D33547

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(17)

DO 7/01/03

Job Completion



CL 07/01/03

I.D.  
in stock.

ws.

LB 07/01/03

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

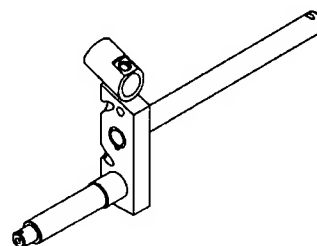
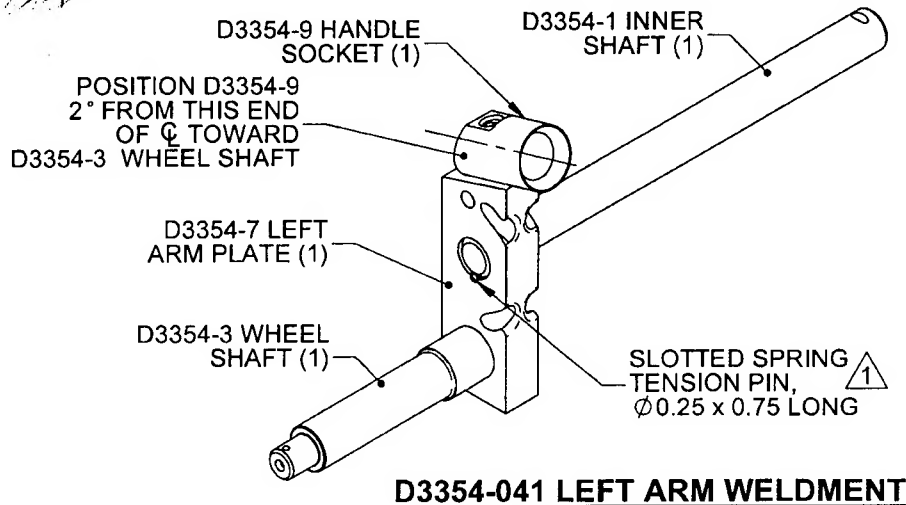
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

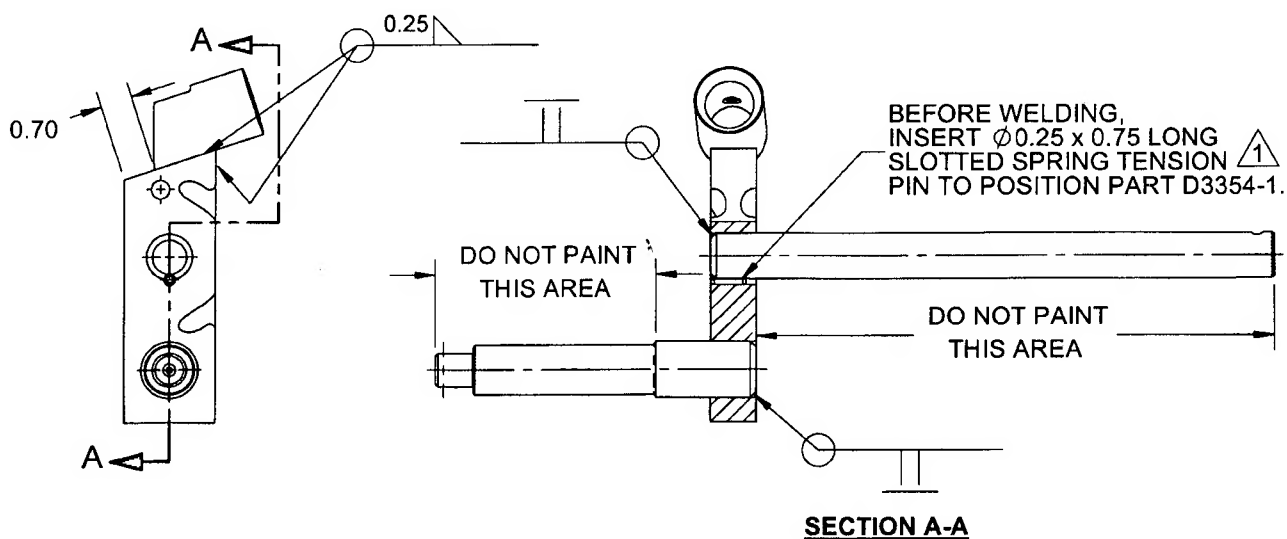


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3354</b>	REV. A SHEET 1 OF 7
DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:4
A	04.12.13	NEW ISSUE	

RELEASED  
06/02/07



**D3354-042 MIRROR  
ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.8
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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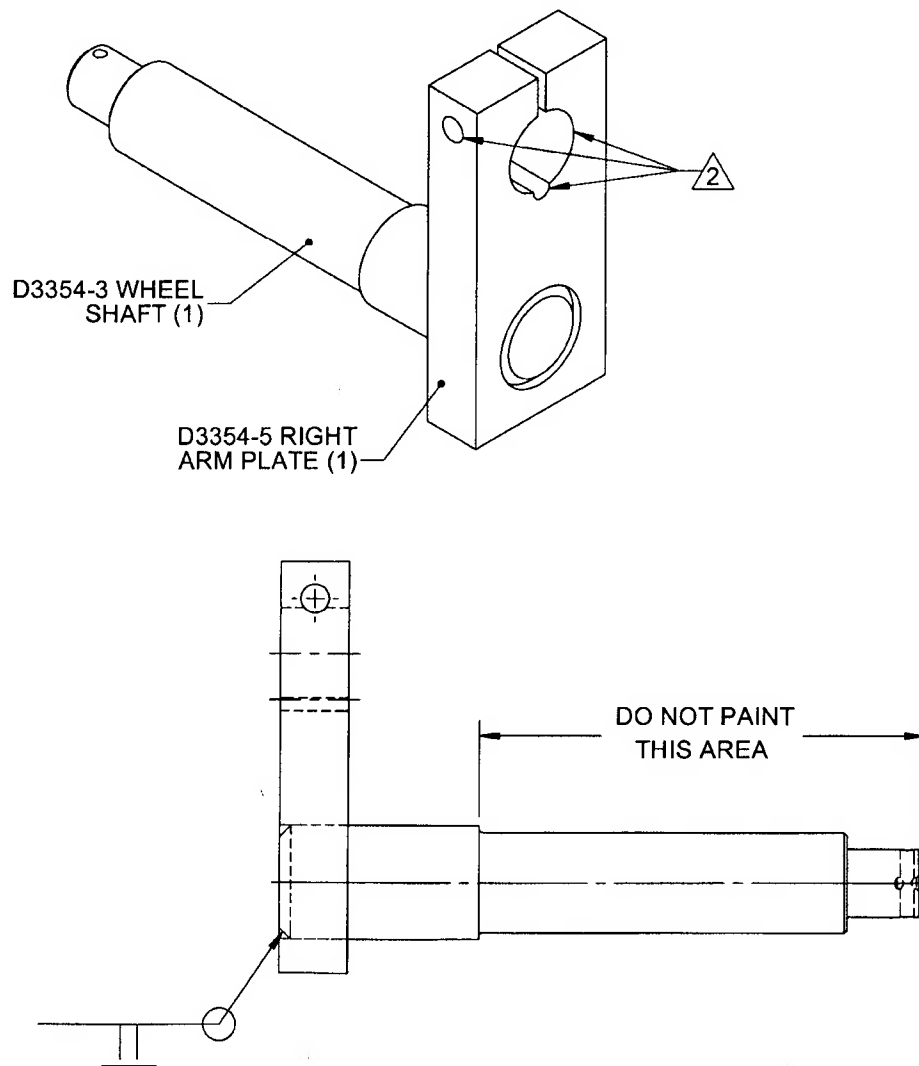
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
06/03/19



**D3354-043 RIGHT ARM WELDMENT**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

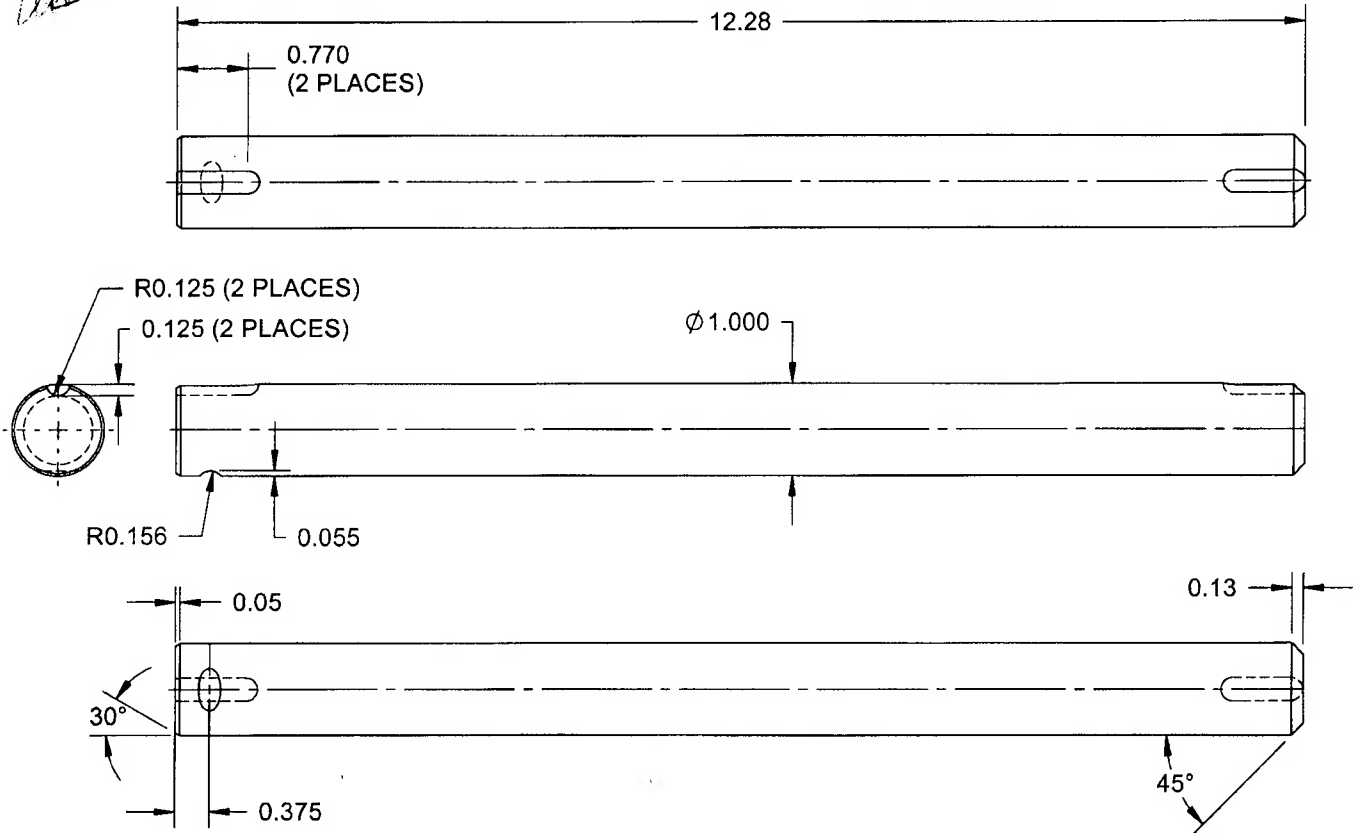
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
36/03/01**D3354-1 INNER SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-01D COPY OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

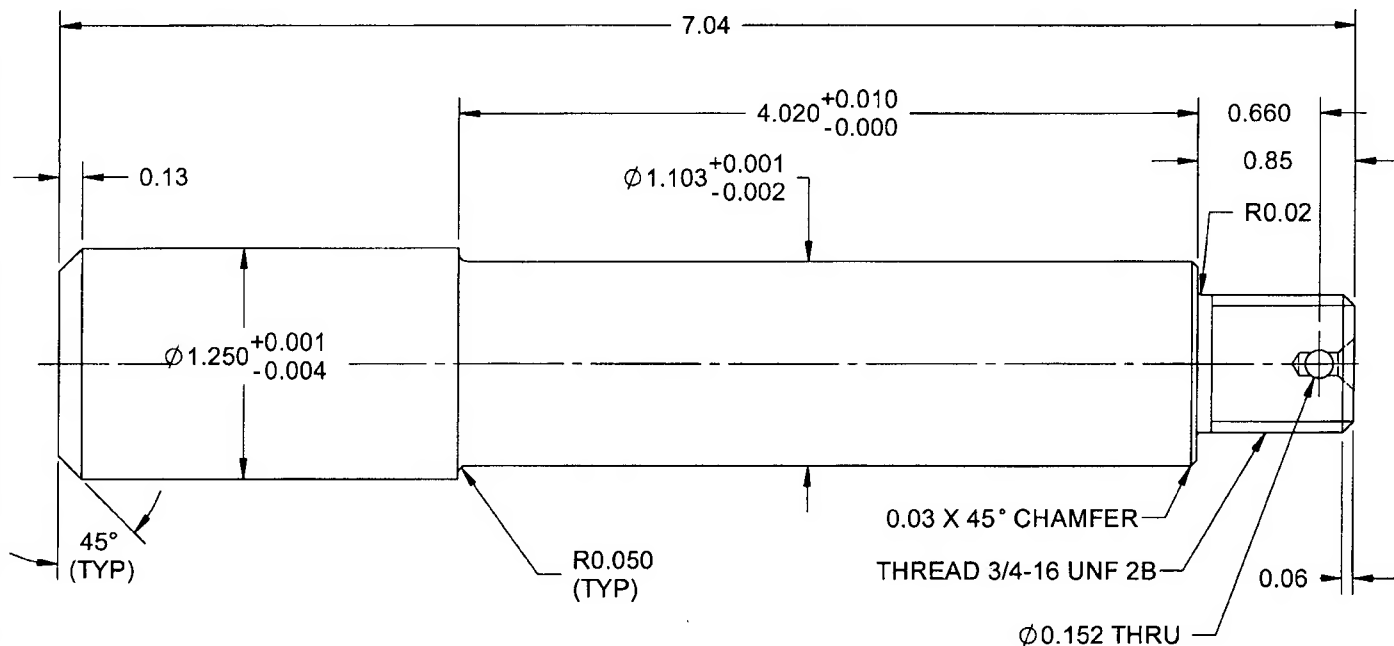
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

**RELEASED**  
*[Handwritten: 06/03/07]***D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE B7/ A29-03/ A322-01 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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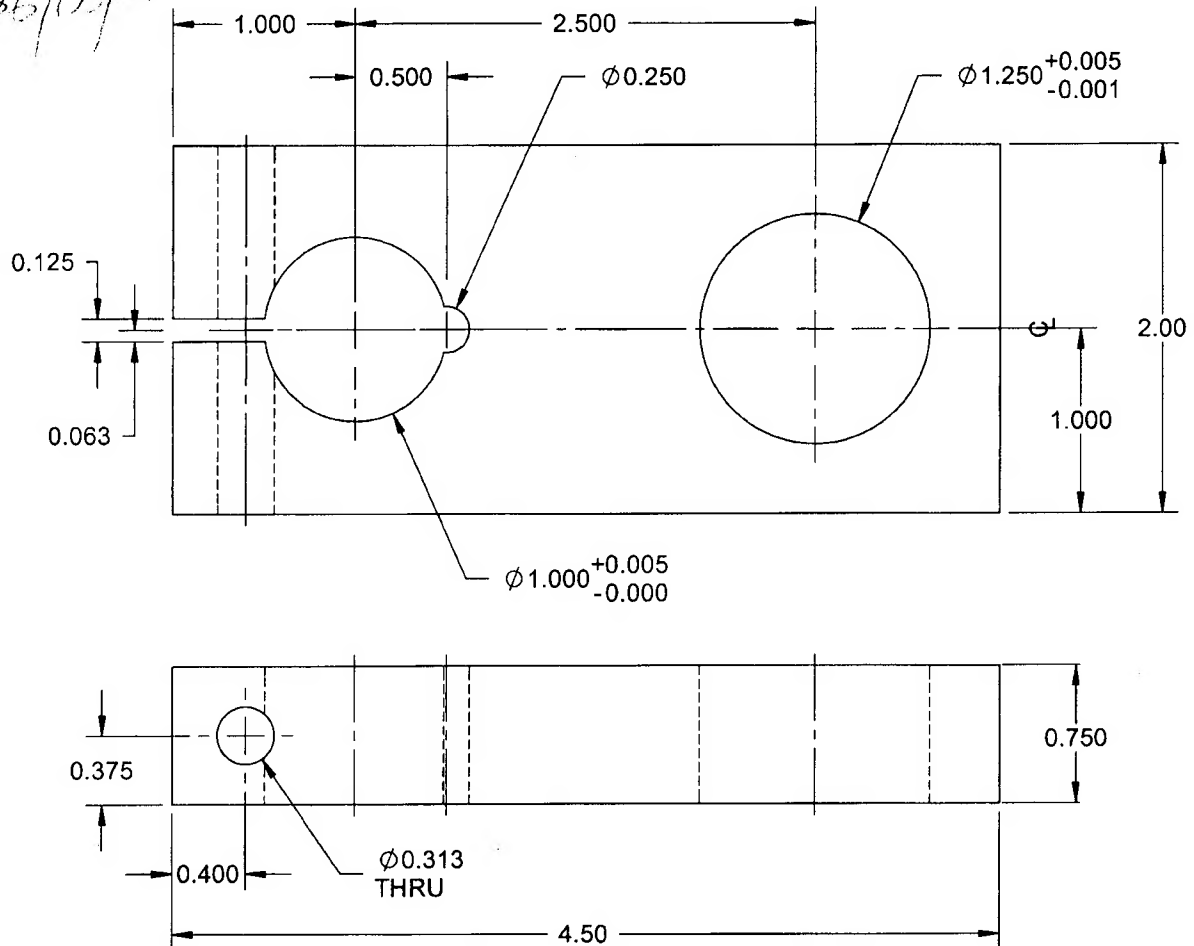
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

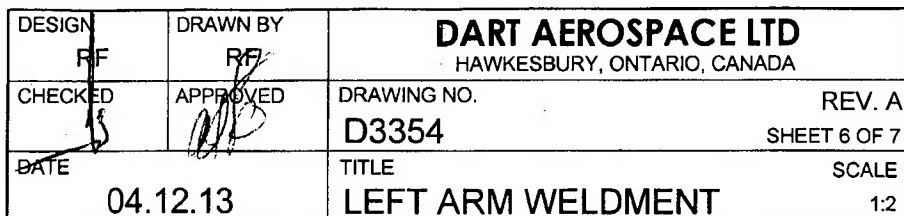
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*26/03/09***D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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RELEASED  
661036



**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD  
STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

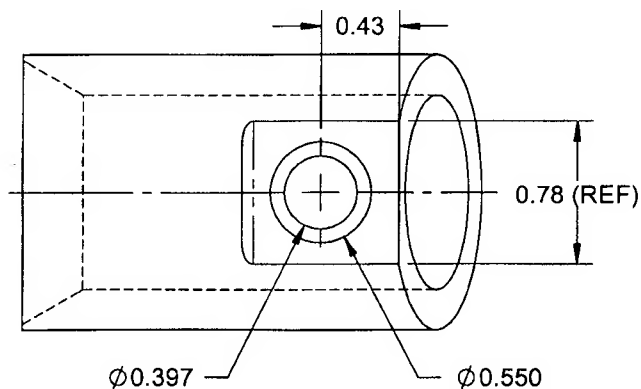
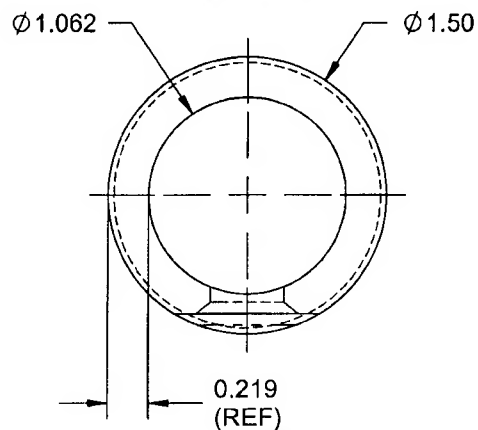
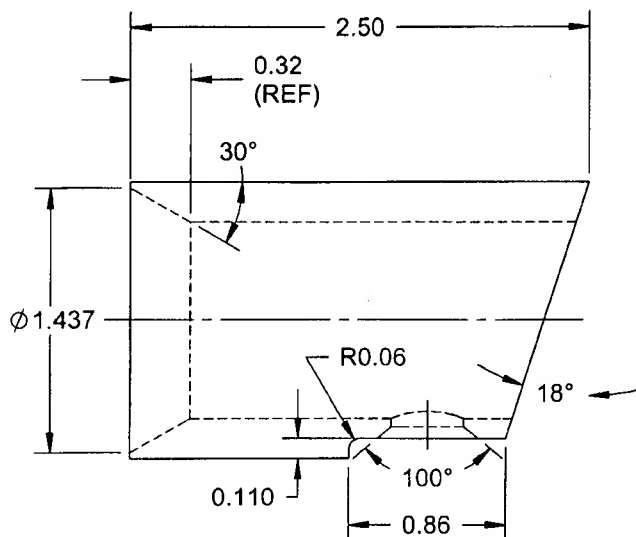
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>
<b>Description:</b>		<b>Part Number:</b>
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

623 594  
622 8255

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.35"	±.030"	5.340"	✓			
1.150"	±.010"	1.152"	✓			
2.500"	±.010"	2.502"	✓			
1.500"	±.010"	1.500"	✓			
.500"	±.010"	.501"	✓			
2.00"	±.030"	1.997"	✓			
1.000"	±.010"	.998"	✓			
.800"	±.010"	.810"	✓			
.200"	±.010"	.200"	✓			
1.00"	±.030"	1.001"	✓			
Ø 1.250"	±.005"	Ø 1.253"	✓			
Ø .250"	±.001"	Ø .251"	✓			
.375"	±.010"	.380"	✓			
.500"	±.010"	.500"	✓			
Ø 1.000"	±.005"	1.002"	✓			
Ø .406"	±.001"	Ø .407"	✓			
6.00"	±.030"	5.994"	✓			

<b>Measured by:</b>	J.F.
<b>Date:</b>	06/12/18

<b>Audited by:</b>	SL
<b>Date:</b>	06/12/18

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

